

Date: Wednesday, 11/03/2009 12:59:23 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46451
 Estimate Number : 12841
 P.O. Number :
 This Issue : 11/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 45933
 Written By :
 Checked & Approved By : JUL 09-03-11
 Comment : Est Rev:A New Issue 07-04-24 JLM

Drawing Name : BALL STUD

Part Number : D36221
 Drawing Number : D3622 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 23/03/2009

Qty: 50 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303H0500 303 HEX BAR .500



Comment: Qty.: 0.1134 f(s)/Unit Total : 3.4020 f(s)
 303 HEX BAR .500"
 Batch: M 108775

SA 05/03/16

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA686 & DWG D3622 ,
 FOLIO REV: 2
 DWG REV: 1

2-DEBURR AS REQUIRED

SA 05/03/16

(51)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 05/03/16

(51)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 09/03/16

(51)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: SA119

SA 09/03/16 (51)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:59:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL STUD

Job Number: 46451

Part Number: D36221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

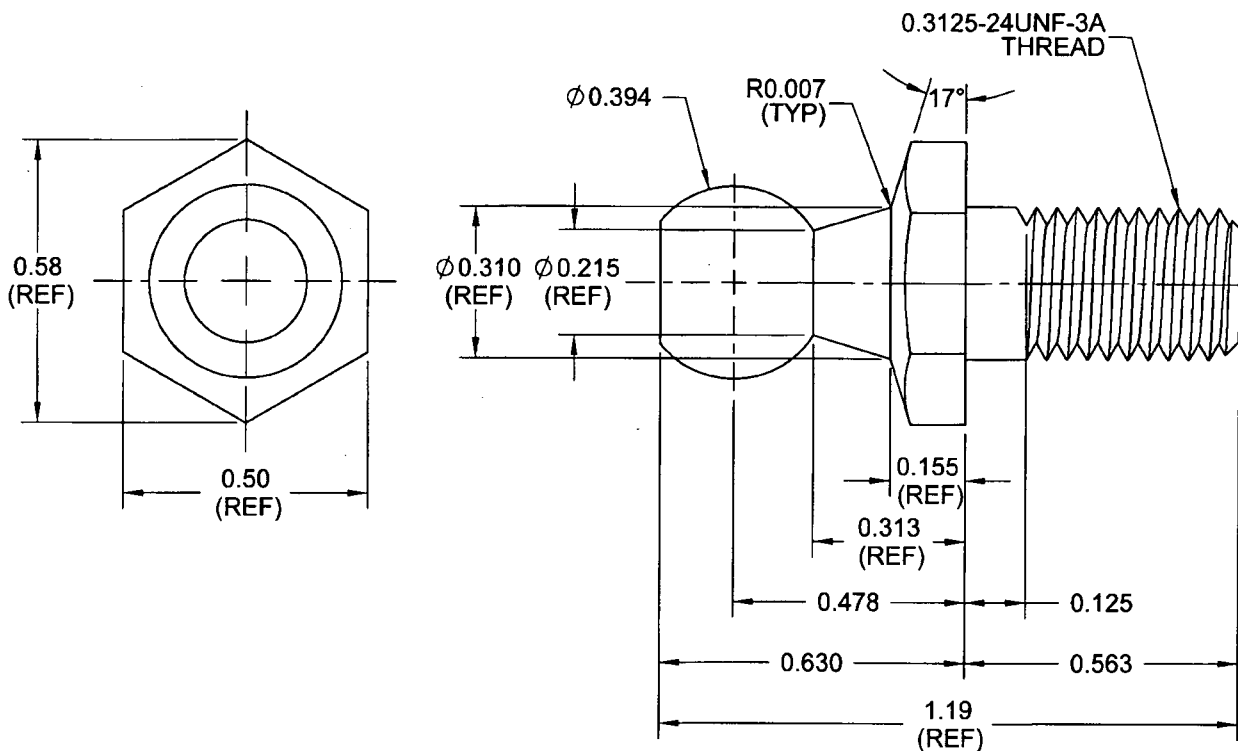
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.07.11
PER BCN# 1001

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3622	REV. A SHEET 1 OF 1
DATE 07.04.13	TITLE BALL STUD		SCALE NTS
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	



D3622-1 BALL STUD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40451

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR (REF. DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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